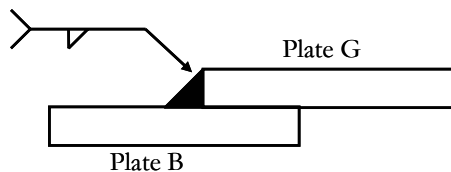
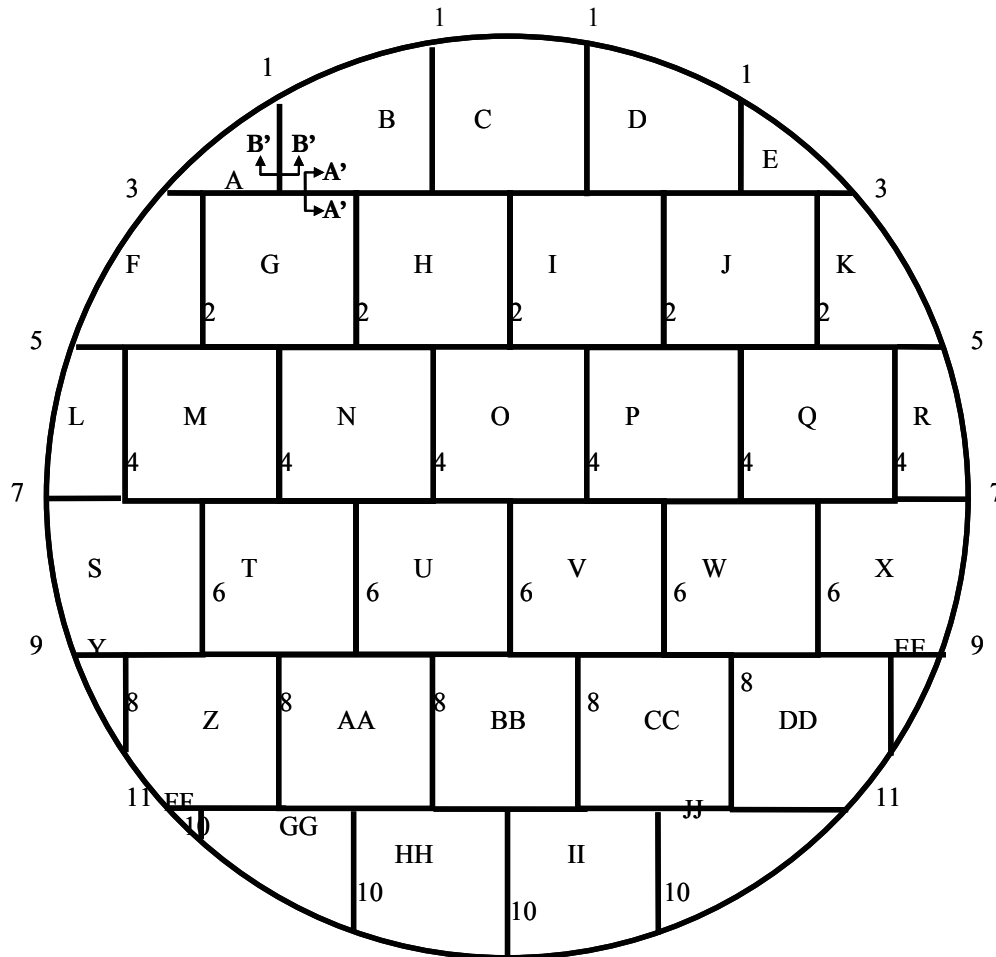


Section WFP 2-12 – Welding Fabrication Procedure

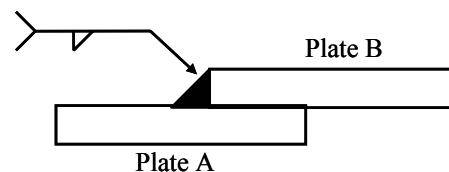
Rev. 0, 8/16/04

Attachment 2, Recommended Sequence for Welding Seams Joining Bottom Plates

**RECOMMENDED SEQUENCE FOR WELDING SEAMS JOINING BOTTOM PLATES**



Section A'-A'



Section B'-B'

Instructions: Place bottom plates in alphabetical order and weld bottom plate in numerical order. When aligning and tack welding No. 2 seams, care should be taken to assure that Seam No. 3 is aligned the entire length. This procedure is repeated across the tank bottom with Seams No. 4 and 5, 6 and 7, 8 and 9, and 10 and 11. The minimum distance the top plate must lap over the bottom plate is 4 times the thickness of the thinner plate. Weld the entire bottom of the tank prior to welding the tank shell plates to the tank bottom.